

BYSTRONIC



Press brake tooling and equipment

**UTENSILI E
ATTREZZATURE
PER PRESSE PIEGATRICI**

Eurostamp Tooling significa qualità, competenza e precisione. Dal 1970 produciamo utensili e attrezzature per la piegatura straordinariamente precisi, offrendo soluzioni di estrema qualità per tutti quei clienti che richiedono costantemente massimi livelli di performance e affidabilità.
“Eurostamp Tooling, the italian secret of quality”

*Eurostamp Tooling means quality, competence, accuracy.
Since 1970 we have been manufacturing outstandingly accurate tooling and providing top quality solutions to all those customers who require the highest levels of performance and reliability.*

“Eurostamp Tooling, the italian secret of quality”





EUROSTAMP TOOLING
the Italian secret of quality



EUROSTAMP TOOLING

the Italian secret of quality

L'azienda è stata creata nel 1970 e, sin da allora, siamo orgogliosi di produrre e commercializzare **utensili e attrezzature per la piegatura** altamente performanti, affidabili e caratterizzati dai più elevati standard di qualità. Il nostro parco macchine utensili a elevata tecnologia e il magazzino con ampia disponibilità ci permettono di soddisfare ogni esigenza e richiesta speciale.

I nostri utensili sono realizzati con **acciai al carbonio e acciai speciali di provenienza italiana**, con tempra a induzione sulle parti usurabili che ne garantisce una **durezza di 55-60 HRC**. Offriamo un'ampia gamma di accessori per presse piegatrici: adattatori inferiori e superiori, sistemi di bloccaggio manuali e pneumatici.

Il nostro ufficio tecnico interno, inoltre, è in grado di studiare i progetti di piegatura personalizzati in modo tempestivo e accurato.

*The company was formed in 1970 and, since then, we have been proud to produce and market high performing, **reliable tools for bending**, which are characterised by the highest quality standards. Our highly-technological machine tool range and large warehouse facilities, allow us to meet every need and special requirement you may have*

*Our tools are made of **medium carbon steel and special Italian-sourced alloy steel**, with induction hardening on the parts subject to wear that guarantees **55-60 HRC hardness**.*

We provide a large range of accessories for press brakes: lower and upper adaptors, manual and pneumatic clamping systems. Our in-house technical office is also able to study fully customised bending projects in a timely and accurate manner.

CHI SIAMO

WHO WE ARE

LA NOSTRA FILOSOFIA

Eurostamp Tooling è un'azienda con cuore italiano e anima internazionale; abbiamo deciso di concentrarci e **specializzarci esclusivamente nella produzione e sviluppo degli utensili di piegatura**, settore in cui abbiamo sviluppato la **più alta tecnologia applicata a ciascuno dei processi interni**.

Il nostro reparto produttivo pone la massima attenzione alla **cura dei dettagli, alla precisione e all'accurato** controllo della qualità con una ispirazione artigianale: selezioniamo i migliori fornitori italiani di materia prima, e investiamo costantemente in **attrezzature di qualità** e in spazi di stoccaggio di ampio respiro.

Poniamo una fortissima attenzione alla formazione dello staff tecnico e produttivo ed investiamo costantemente in **ricerca e sviluppo perché crediamo fortemente che il modo migliore per soddisfare i nostri clienti sia il superamento delle loro aspettative con soluzioni innovative e un supporto pre e post vendita di elevato livello**. Il team commerciale lavora quotidianamente a fianco dello staff tecnico e produttivo per diffondere ovunque la nostra filosofia di marchio.

OUR PHILOSOPHY

*Eurostamp Tooling is an Italian company with an international soul, we decided to **focus only on manufacturing and engineering of tooling for press brakes**, so we invested all of **our resources on the state-of-art technologies applied to any of internal processes**.*

*Our production department put the highest care on every detail, on the maximum **accuracy and on the minute quality control**, according to a craftsman mood: we selected the best raw materials suppliers among the Italian market, beside we have been steadily investing on the **highest quality equipment** and in a precisely organised warehouse.*

*We put a strong attention to train our production and engineering staff and to invest on **research and development activities** because we believe that the best way to satisfy the customer demands is to overcome his expectations with innovative solutions and with a high level pre and post sales support. Our sales staff works daily beside the production and the engineering departments in order to spread worldwide our brand philosophy.*



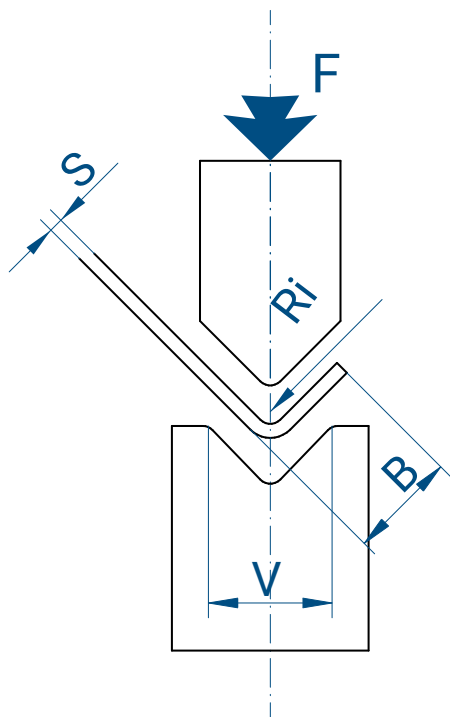
*Our staff are specialists who **follow every production phase from choosing** the best steel to the procedures for machining, hardening and grinding of each piece. We are using only 100% Italian quality steel for granting always **the best accuracy and the conformity with the highest standards specifications**.*

Gli specialisti che compongono il nostro staff **controllano ogni fase produttiva**, dalla scelta delle leghe e degli acciai grezzi, **alle procedure di fresatura**, tempra e rettifica di ogni pezzo. Usiamo acciaio al 100% italiano per garantire massima **precisione e caratteristiche meccaniche ad alto standard qualitativo**.

LE COMPETENZE OUR COMPETENCES

Calcolo della forza di piega in aria

Air bending force calculation



S	Spessore lamiera - mm Sheet metal thickness - mm	Ri	Raggio interno Inside radius
V	Larghezza del V V-opening	R	Alluminio 20-25 kg/mm ² Aluminium 20-25 kg/mm ²
F	Forza in T/m Force in T/m	R	Acciaio dolce 40-45 kg/mm ² Mild steel 40-45 kg/mm ²
B	Bordo minimo Shortest edge	R	Inox 65-70 kg/mm ² Stainless steel 65-70 kg/mm ²

$$F = \frac{S^2 \times 2 \times R}{1.4 \times V} = \dots \text{ ton/m}$$

Relazione tra spessore lamiera e larghezza V

Sheet metal thickness/V-shape width ratio

S	Spessore lamiera - mm Sheet metal thickness - mm	0,5-2,5	3-8	9-10	12 o più 12 or more
V	Larghezza del V "V" width	6 S	8 S	10 S	12 S

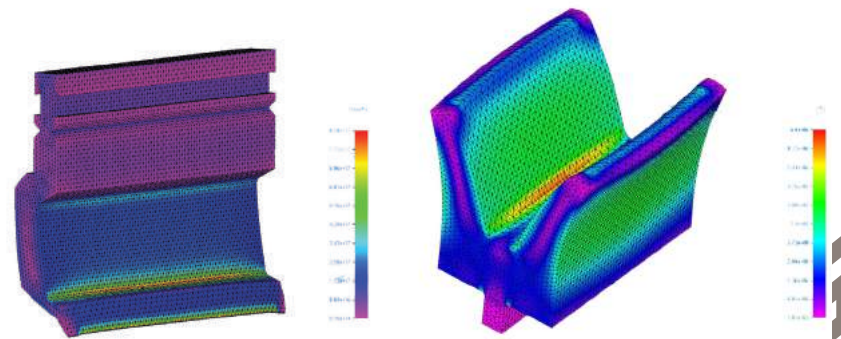


Tabella di piegatura in aria - Acciaio dolce / Air bending table - Mild Steel

S			mm	0,5	0,6	0,8	1	1,2	1,5	2	2,5	3	4	5	6	8	10	12	15	20	25	30	
6	4	1		3	4	7	11	16															
8	5,5	1,3			4	5	8	12	17														
10	7	1,6				4	7	10	15	27													
12	8,5	2					6	8	13	22	35												
16	11	2,6						6	9	17	26	38											
20	14	3,3							8	13	21	30	54										
25	17,5	4								11	17	24	42	67									
32	22	5									13	19	34	52	75								
40	28	6,5										15	27	42	60	107							
50	35	8											21	33	48	85	134						
63	45	10												26	38	68	105						
80	55	13													30	53	85	120					
100	71	16														43	67	96	150				
125	89	20															53	78	120	215			
160	113	26																60	95	170	265		
200	140	33																	75	135	210	300	
250	175	41																		108	170	240	
320	226	53																			85	130	190
V	B	Ri																					F

t/m

t/m

Tabella di piegatura in aria - Acciaio inox / Air bending table - Stainless Steel

S			mm	0,5	0,6	0,8	1	1,2	1,5	2	2,5	3	4	5	6	8	10	12	15	20	25	30	
6	4	1		5	6	11	17	25															
8	5,5	1,3			6	8	12	19	26														
10	7	1,6				6	11	16	23	42													
12	8,5	2					9	12	20	34	54												
16	11	2,6						9	14	26	40	59											
20	14	3,3							12	20	33	47	84										
25	17,5	4								17	26	37	65	104									
32	22	5									20	30	53	81	117								
40	28	6,5										23	42	65	93	166							
50	35	8											33	51	75	132	208						
63	45	10												40	59	106	163						
80	55	13													47	82	132	187					
100	71	16														67	104	149	233				
125	89	20															82	121	187	334			
160	113	26																93	148	264	412		
200	140	33																	117	210	327	467	
250	175	41																		168	264	373	
320	226	53																			132	202	296
V	B	Ri																					F

t/m

t/m



Gli utensili superiori elencati in questa sezione possono essere installati sulle piegatrici Bystronic/Beyeler dotate dei seguenti stili di connessione:
Upper tooling listed on this section could be installed on the Bystronic/Beyeler press brakes equipped with the following clamping styles:

Bystronic/Beyeler Type RFA

Bystronic/Beyeler Type RF

Bystronic/Beyeler Type R

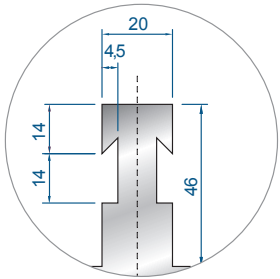
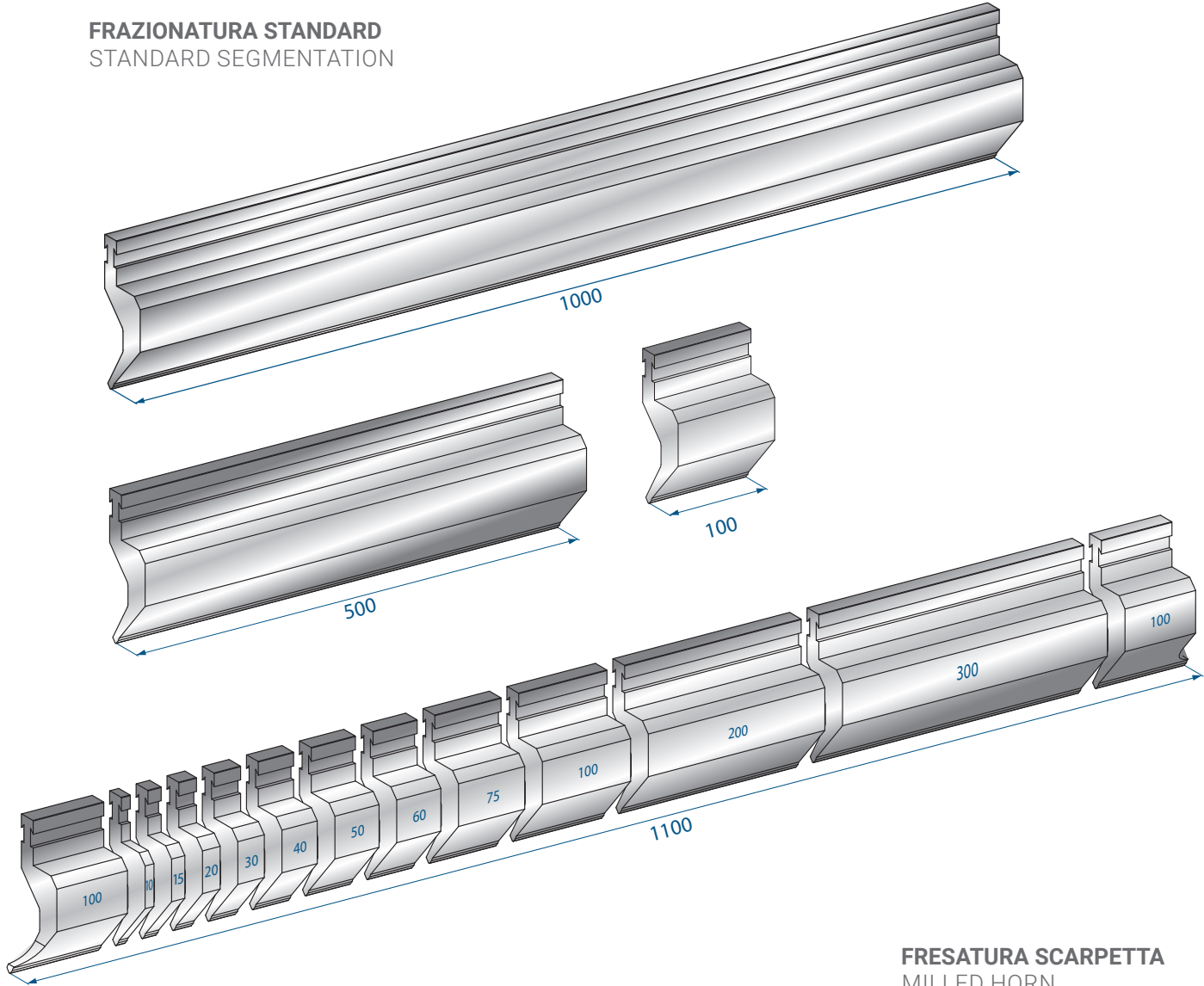
Questi utensili possono essere installati anche su altre piegatrici tramite adattatori superiori e inferiori.

These tooling can also be installed on other press brakes by using the correct upper and lower adapters.

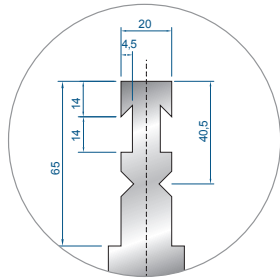
BYSTRONIC

PUNZONI / PUNCHES	10	• Punzoni / Punch type RF-A 30°	23-25
• Frazionatura standard / Standard segmentation	10	MATRICI / DIES	27
• Modifiche a richiesta / Modifications on request	11	• Frazionatura standard / Standard segmentation	27
BYSTRONIC R		• Modifiche a richiesta / Modifications on request	29
• Punzoni / Punch type R 86°	13	• Matrici 1V / 1V dies 88°	31-35
• Punzoni / Punch type R 85°	14-15	• Matrici 1V / 1V dies 85°	37
• Punzoni / Punch type R 30°	17-19	• Matrici 1V / 1V dies 60°	39
• Punzoni / Punch type R 28°	20	• Matrici 1V / 1V dies 30°	41-47
BYSTRONIC RF-A		• Piegaschiaccia / Flattening hemming tools	49-50
• Punzoni / Punch type RF-A 88°	21		

FRAZIONATURA STANDARD
STANDARD SEGMENTATION

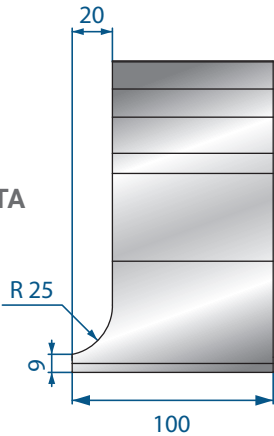


BYSTRONIC R
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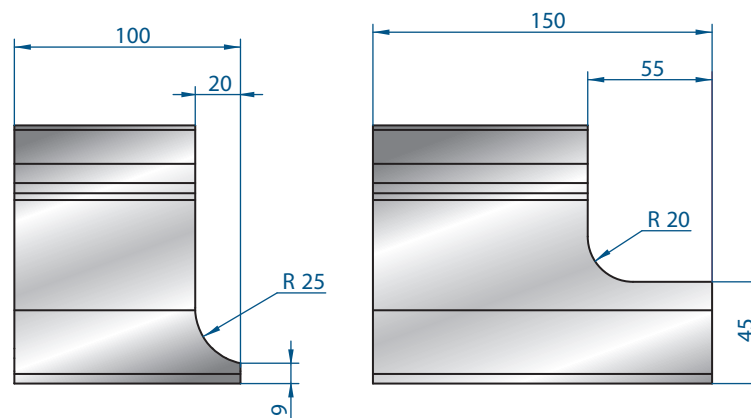


BYSTRONIC RF-A
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FRESATURA SCARPETTA
MILLED HORN



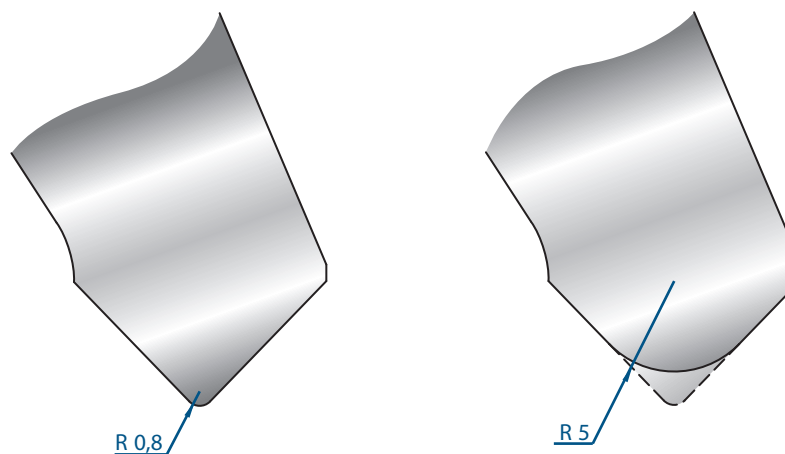
SCARPETTE SPECIALI
SPECIAL HORNS



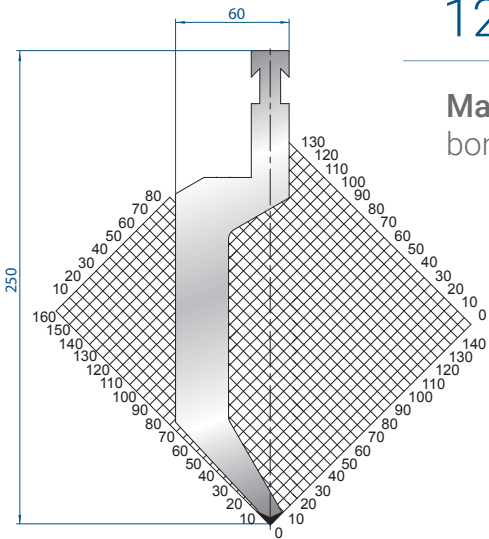
TAGLI A RICHIESTA
SPECIAL SEGMENTATION



MODIFICA RAGGIO
RADIUS MODIFICATION



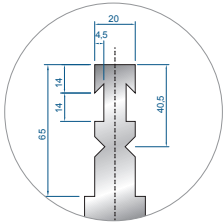




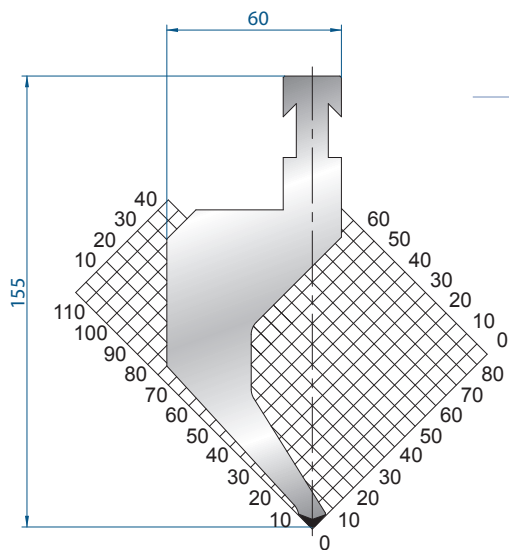
1298

Mat = 42CrMo4
bonificato / tempered
H = 250.00
Max T/m = 60
 α = 86°
R = 1.5

500 mm	25,0 kg
1100 mm FRAZ. / SECT.	55,0 kg
100 mm	5,0 kg



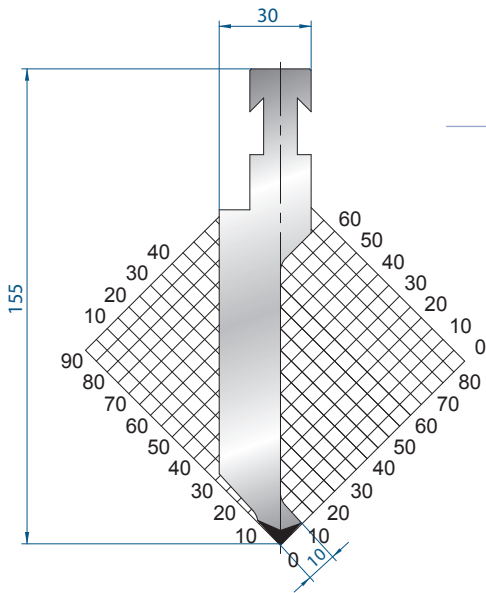
ATTACCO RF-A
INCLUSO SU RICHIESTA
RF-A TANG INCLUDED
ON DEMAND



1216

Mat = C45
bonificato / tempered
H = 155.00
Max T/m = 50
 α = 85°
R = 1.5

1000 mm	30,0 kg
500 mm	15,0 kg
1100 mm FRAZ. / SECT.	30,0 kg
100 mm	3,0 kg

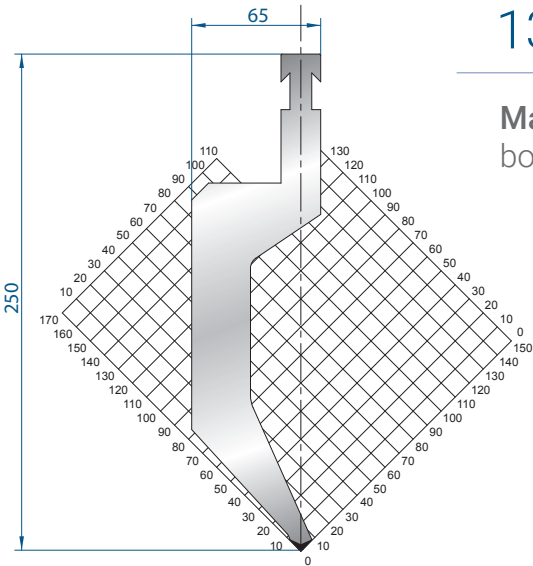


1218

Mat = C45
bonificato / tempered
H = 155.00
Max T/m = 100
 α = 85°
R = 1

1000 mm	23,0 kg
500 mm	12,5 kg
1100 mm FRAZ. / SECT.	30,0 kg
100 mm	3,0 kg

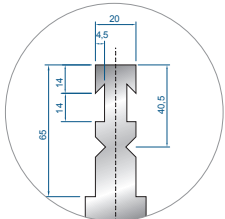




1321

Mat = 42CrMo4
bonificato / tempered
H = 250.00
Max T/m = 100
 α = 85°
R = 1.5

500 mm	27,9 kg
1100 mm FRAZ. / SECT.	61,0 kg
100 mm	5,6 kg

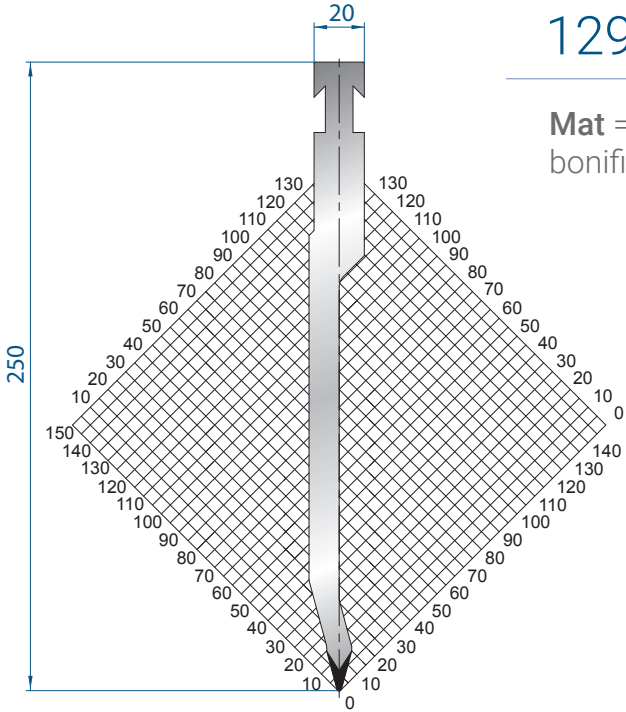


ATTACCO RF-A
INCLUSO SU RICHIESTA
RF-A TANG INCLUDED
ON DEMAND



BYSTRONIC
R STYLE

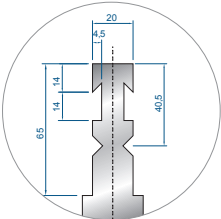




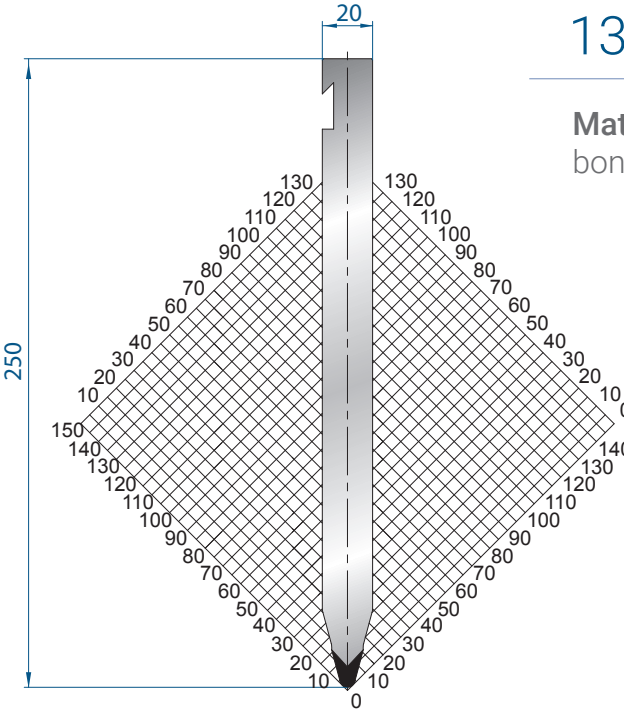
1299

Mat = 42CrMo4
bonificato / tempered
H = 250.00
Max T/m = 80
 α = 30°
R = 1

500 mm	13,3 kg
1100 mm FRAZ. / SECT.	29,2 kg
100 mm	2,6 kg



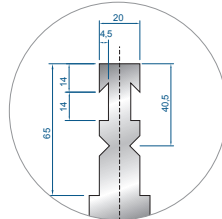
ATTACCO RF-A
INCLUSO SU RICHIESTA
RF-A TANG INCLUDED
ON DEMAND



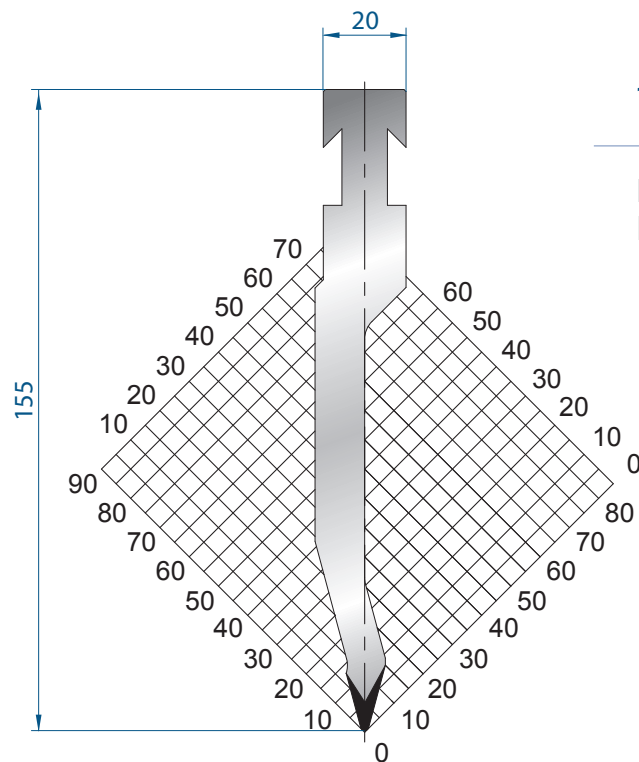
1300

Mat = 42CrMo4
bonificato / tempered
H = 250.00
Max T/m = 120
 α = 30°
R = 3

500 mm	21,0 kg
1100 mm FRAZ. / SECT.	46,0 kg
100 mm	4,2 kg



ATTACCO RF-A
INCLUSO SU RICHIESTA
RF-A TANG INCLUDED
ON DEMAND



1220

Mat = C45
bonificato / tempered

H = 155.00

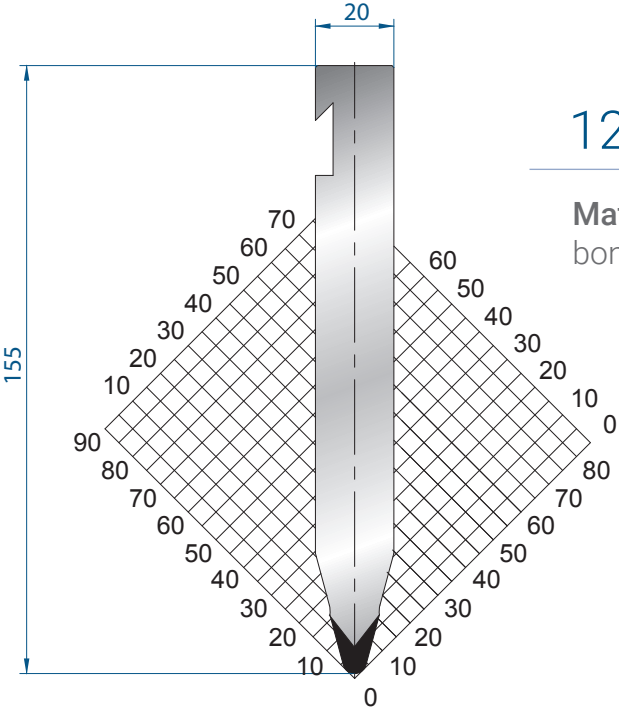
Max T/m = 80

α = 30°

R = 1

1000 mm	16,0 kg
500 mm	8,0 kg
1100 mm FRAZ. / SECT.	16,0 kg
100 mm	1,6 kg

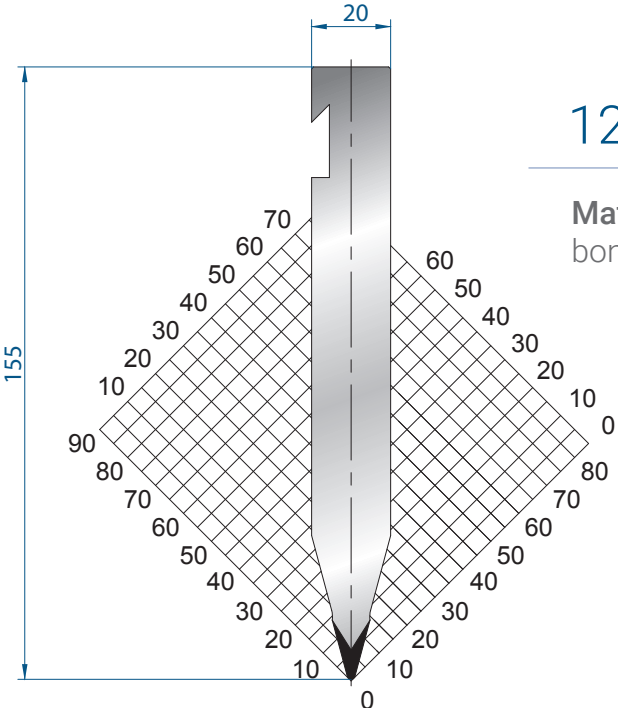




1225

Mat = C45
bonificato / tempered
H = 155.00
Max T/m = 100
α = 30°
R = 3

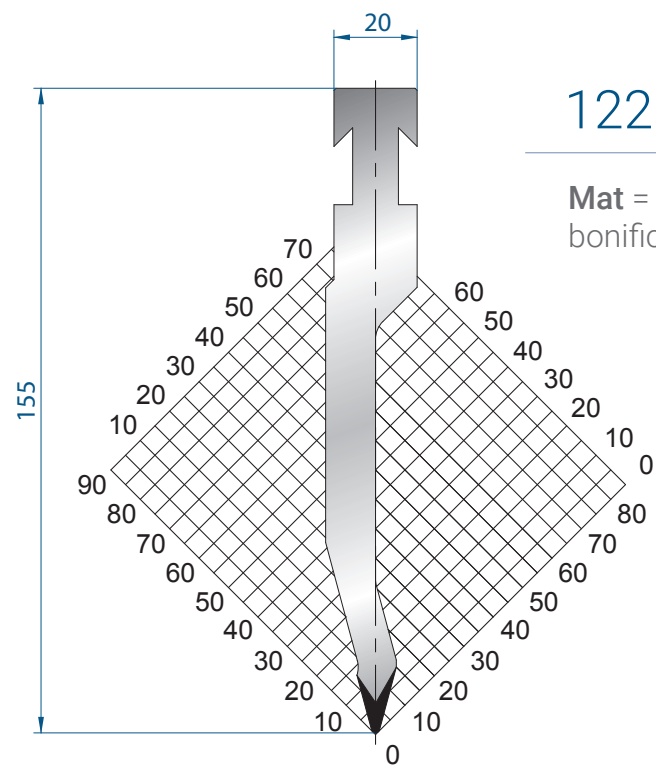
1000 mm	16,0 kg
500 mm	8,0 kg
1100 mm FRAZ. / SECT.	16,0 kg
100 mm	1,6 kg



1226

Mat = C45
bonificato / tempered
H = 155.00
Max T/m = 100
α = 30°
R = 1

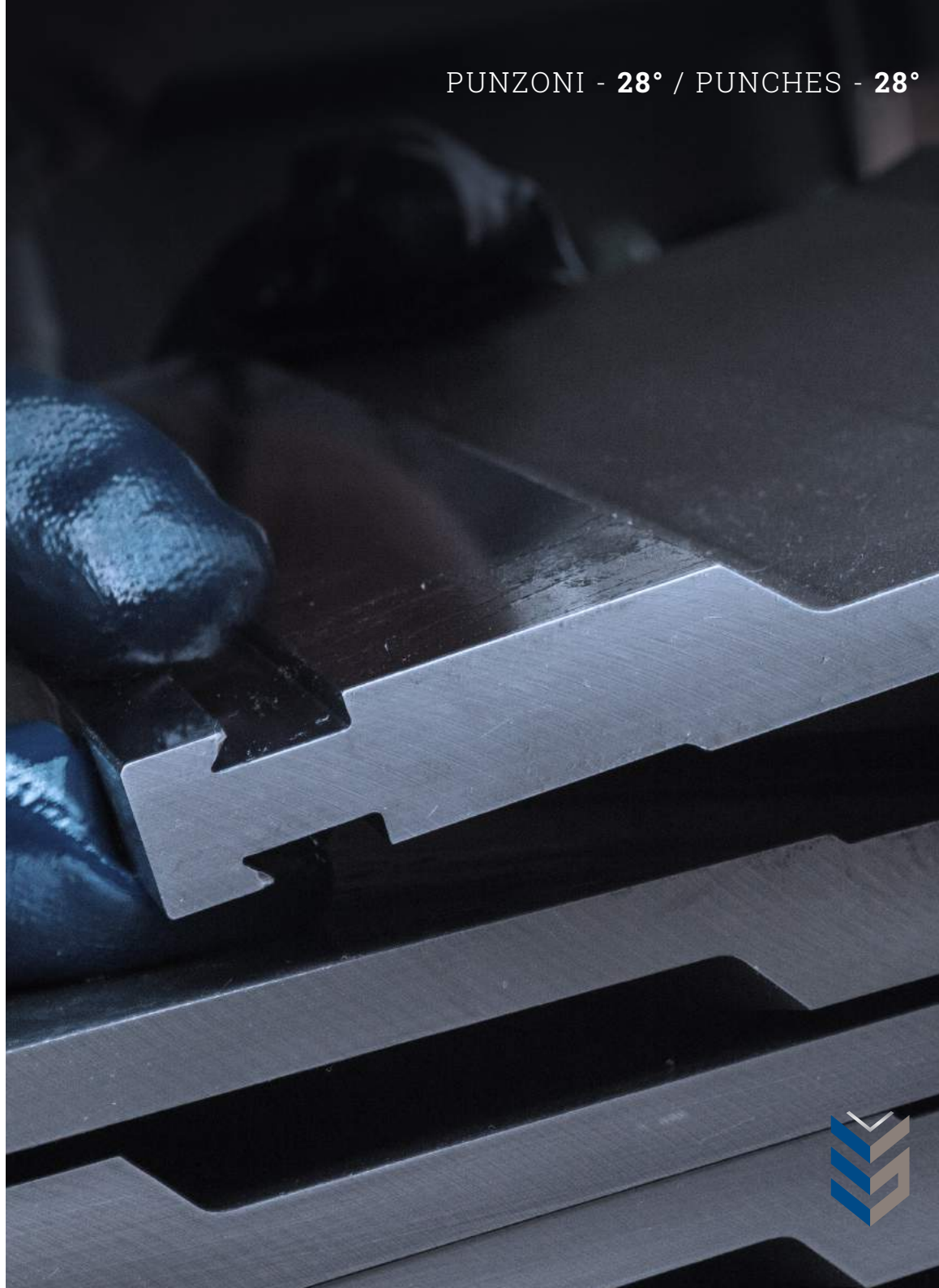
1000 mm	21,0 kg
500 mm	10,0 kg
1100 mm FRAZ. / SECT.	21,0 kg
100 mm	2,0 kg

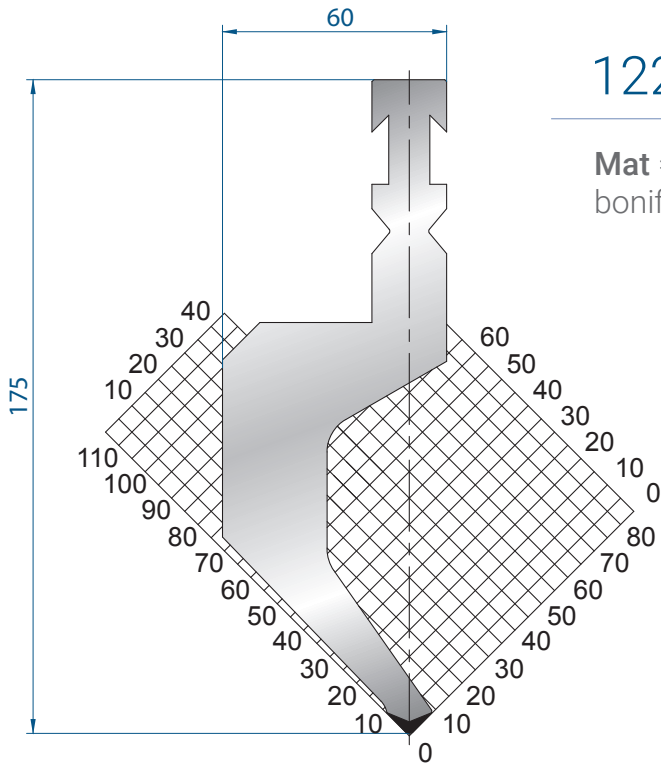


1221

Mat = C45
bonificato / tempered
H = 155.00
Max T/m = 80
 α = 28°
R = 1

1000 mm	16,0 kg
500 mm	8,0 kg
1100 mm FRAZ. 7 SECT.	16,0 kg
100 mm	1,6 kg

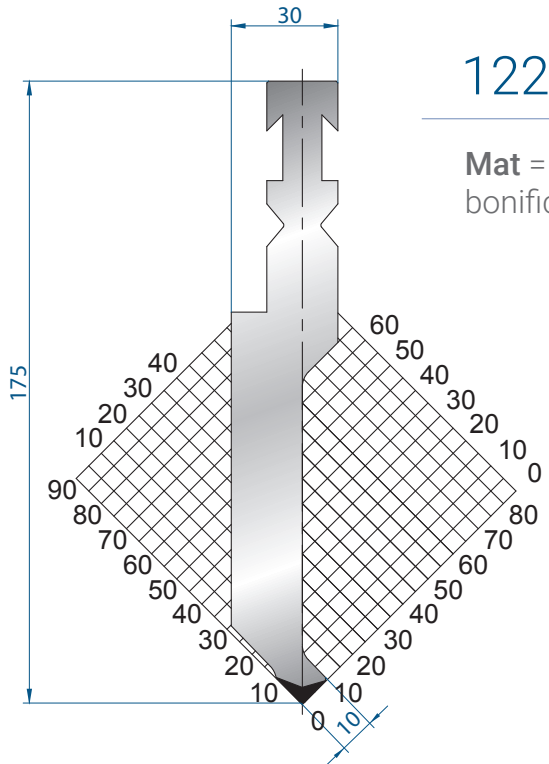




1227

Mat = C45
bonificato / tempered
H = 175.00
Max T/m = 50
α = 88°
R = 1.5

1000 mm	33,0 kg
500 mm	16,0 kg
1100 mm FRAZ. / SECT.	33,0 kg
100 mm	3,2 kg



1229

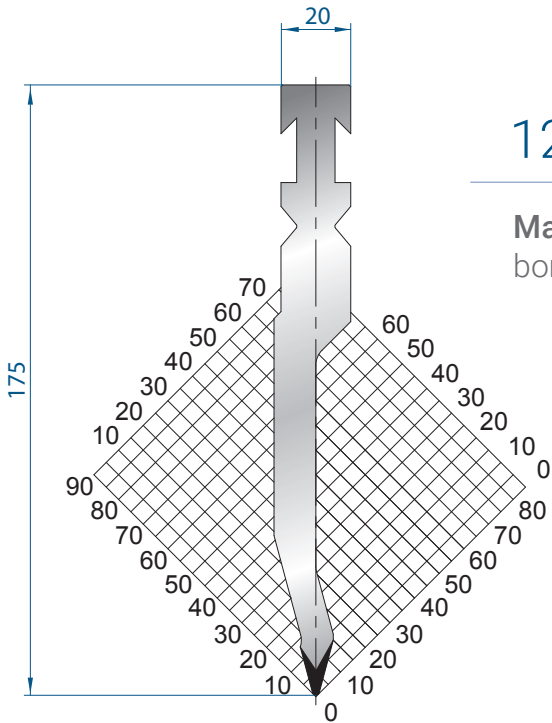
Mat = C45
bonificato / tempered
H = 175.00
Max T/m = 100
α = 88°
R = 1

1000 mm	26,0 kg
500 mm	13,0 kg
1100 mm FRAZ. / SECT.	26,0 kg
100 mm	2,6 kg



BYSTRONIC
RF-A STYLE

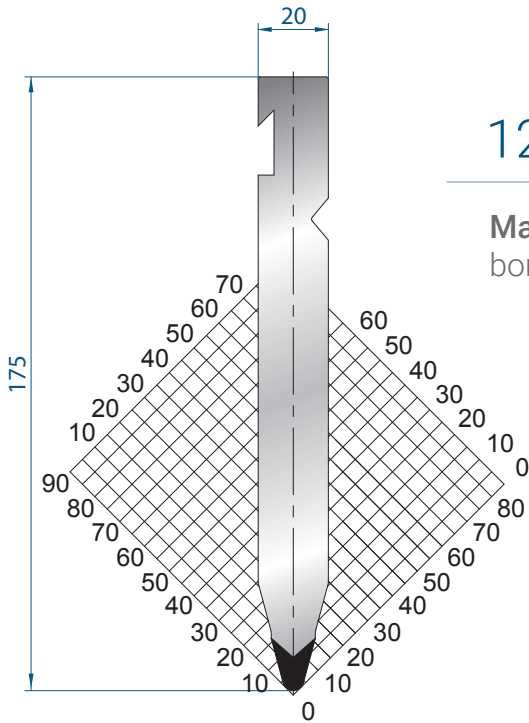




1230

Mat = C45
bonificato / tempered
H = 175.00
Max T/m = 80
α = 30°
R = 1

1000 mm	16,0 kg
500 mm	8,0 kg
1100 mm FRAZ. / SECT.	16,0 kg
100 mm	1,6 kg



1231

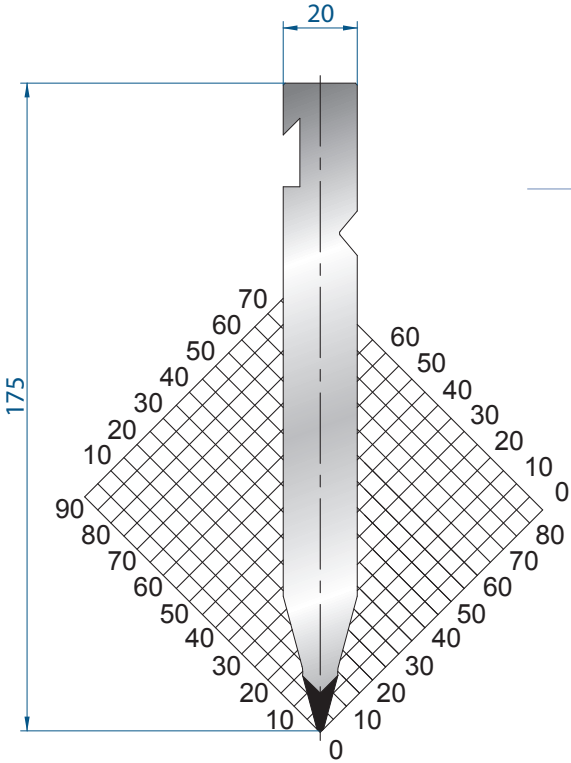
Mat = C45
bonificato / tempered
H = 175.00
Max T/m = 100
α = 30°
R = 3

1000 mm	25,0 kg
500 mm	12,0 kg
1100 mm FRAZ. / SECT.	25,0 kg
100 mm	2,4 kg



BYSTRONIC
RF-A STYLE





1232

Mat = C45
bonificato / tempered
H = 175.00
Max T/m = 100
α = 30°
R = 1

1000 mm	25,0 kg
500 mm	12,0 kg
1100 mm FRAZ. / SECT.	25,0 kg
100 mm	2,4 kg



Gli utensili inferiori elencati in questa sezione possono essere installati sulle piegatrici:

Lower tooling listed on this section could be installed on the following press brakes:

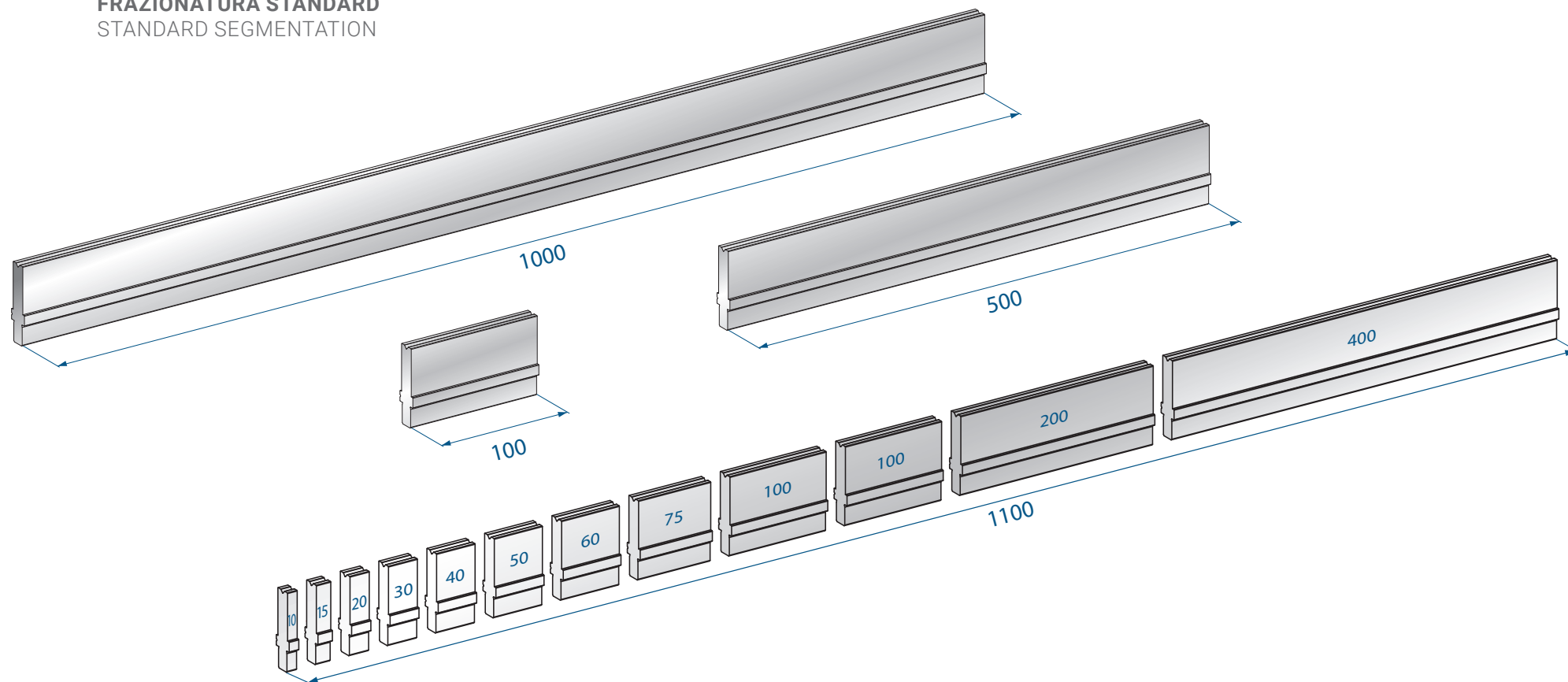
Bystronic/Beyeler, Trumpf, Darley, Safan, SMD e su altre piegatrici equipaggiate con Sistema NSCR.

Bystronic/Beyeler, Trumpf, Darley, Safan, SMD and on other press brakes equipped with System NSCR.

Questi utensili possono essere installati che su altre piegatrici tramite adattatori superiori e inferiori

These tooling are could also be installed on other press brakes by using the correct upper and lower adapters

FRAZIONATURA STANDARD
STANDARD SEGMENTATION



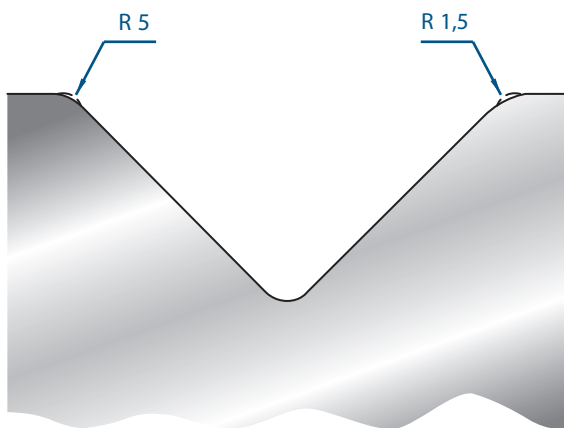


BYSTRONIC
STYLE

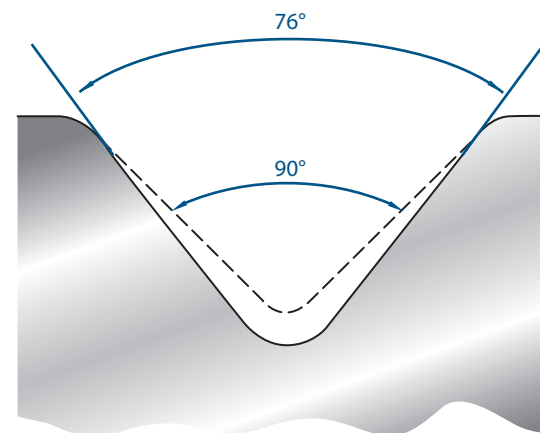




TAGLI A RICHIESTA
SPECIAL SEGMENTATION



MODIFICA RAGGIO
RADIUS MODIFICATION

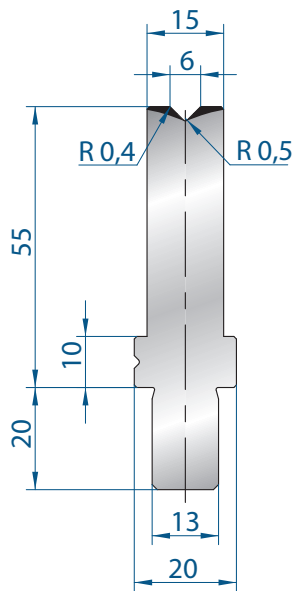


MODIFICA ANGOLO
ANGLE MODIFICATION



BYSTRONIC
STYLE

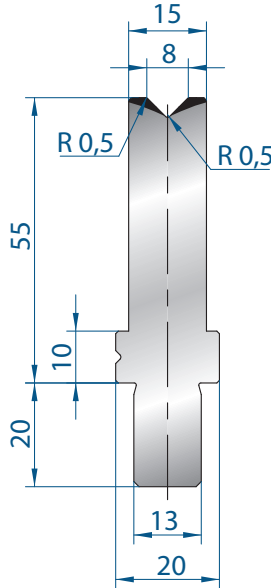




3241

Mat = C45
Max T/m = 100
 $\alpha = 88^\circ$

1000 mm	8,0 kg
500 mm	4,0 kg
1100 mm FRAZ. / SECT.	8,0 kg
100 mm	0,8 kg

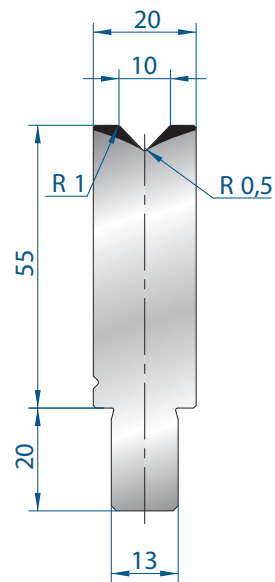


3242

Mat = C45
Max T/m = 100
 $\alpha = 88^\circ$

1000 mm	9,0 kg
500 mm	4,0 kg
1100 mm FRAZ. / SECT.	9,0 kg
100 mm	0,8 kg

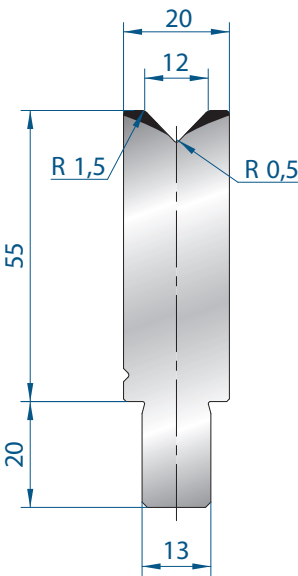




3106

Mat = C45
Max T/m = 100
 $\alpha = 88^\circ$

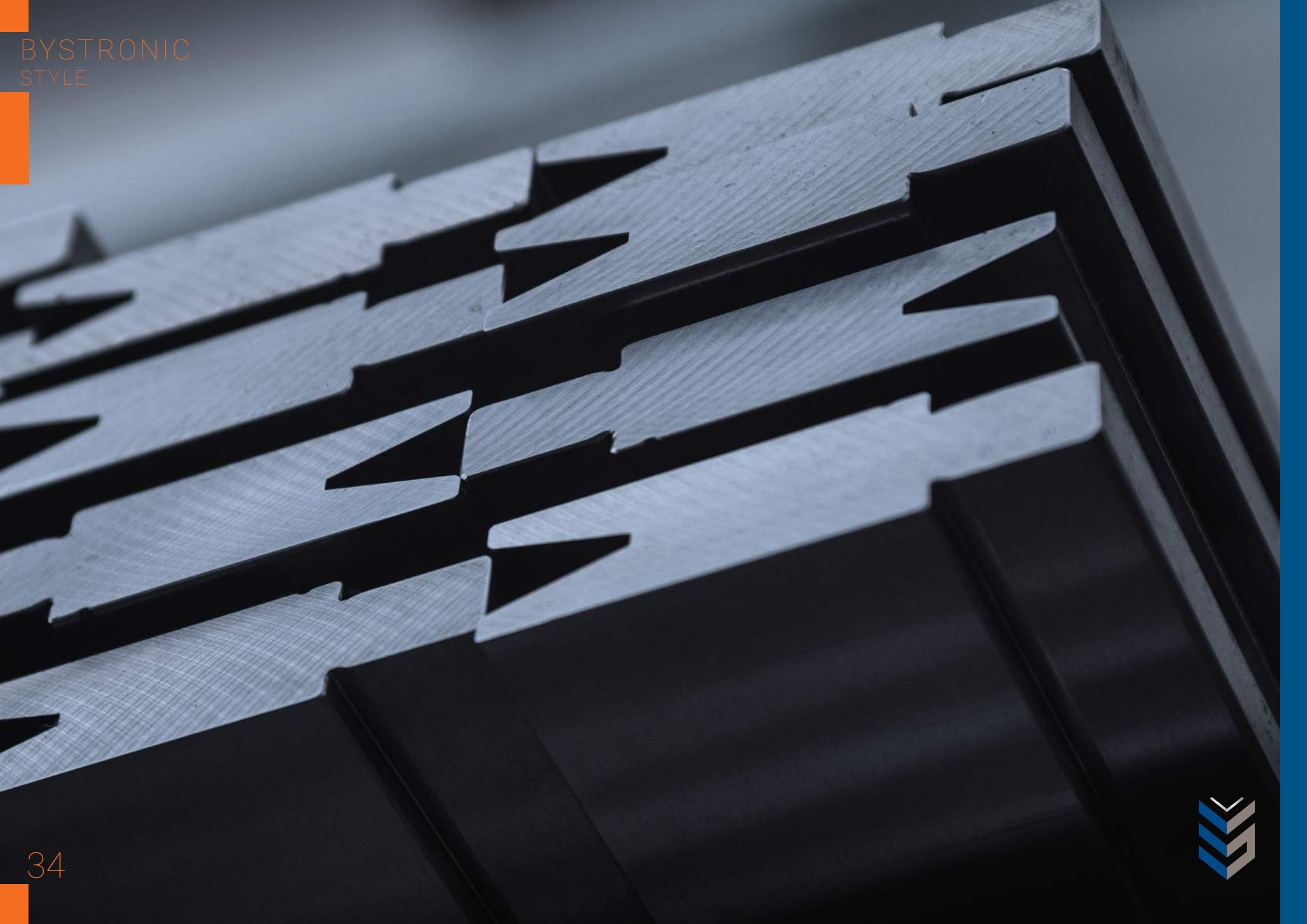
1000 mm	10,0 kg
500 mm	5,0 kg
1100 mm FRAZ. / SECT.	10,0 kg
100 mm	1,0 kg

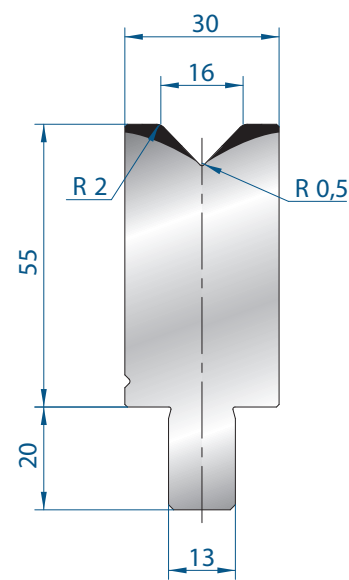


3107

Mat = C45
Max T/m = 100
 $\alpha = 88^\circ$

1000 mm	10,0 kg
500 mm	5,0 kg
1100 mm FRAZ. / SECT.	10,0 kg
100 mm	1,0 kg

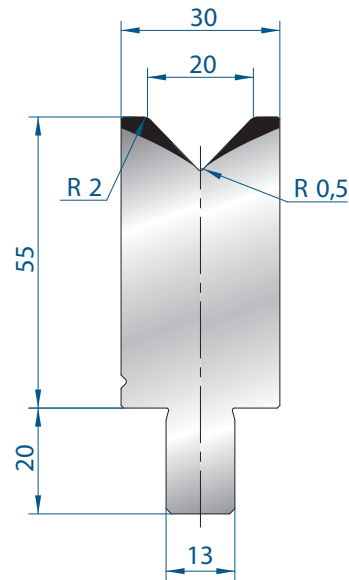




3108

Mat = C45
Max T/m = 100
 $\alpha = 88^\circ$

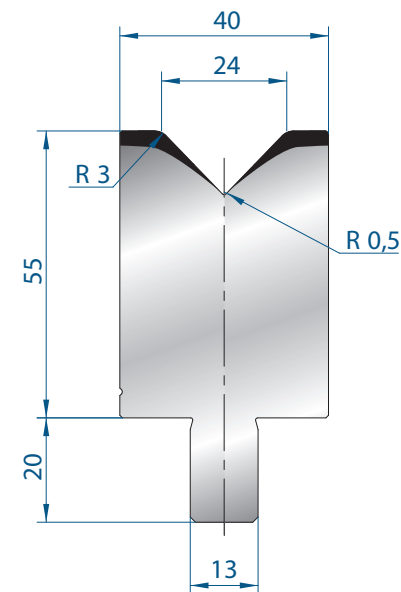
1000 mm	14,0 kg
500 mm	7,0 kg
1100 mm FRAZ. / SECT.	14,0 kg
100 mm	1,4 kg



3109

Mat = C45
Max T/m = 100
 $\alpha = 88^\circ$

1000 mm	14,0 kg
500 mm	7,0 kg
1100 mm FRAZ. / SECT.	14,0 kg
100 mm	1,4 kg



3110

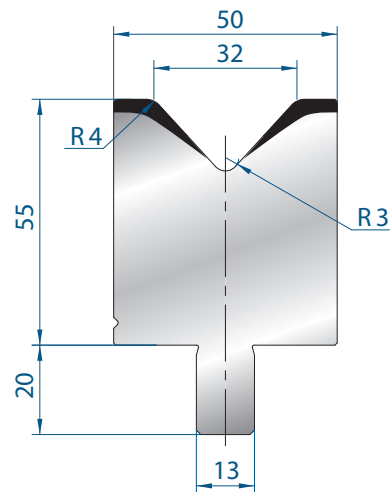
Mat = C45
Max T/m = 100
 $\alpha = 88^\circ$

1000 mm	18,0 kg
500 mm	9,0 kg
1100 mm FRAZ. / SECT.	18,0 kg
100 mm	1,8 kg



BYSTRONIC
STYLE

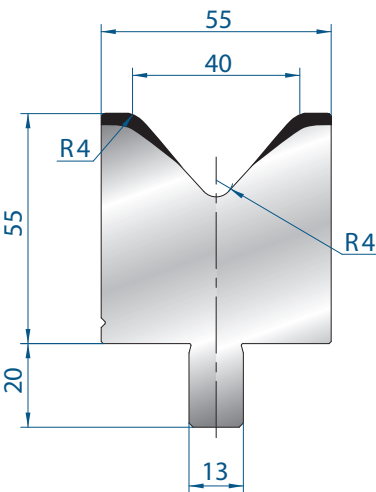




3111

Mat = C45
Max T/m = 100
 $\alpha = 85^\circ$

1000 mm	21,0 kg
500 mm	10,0 kg
1100 mm FRAZ. / SECT.	21,0 kg
100 mm	2,0 kg

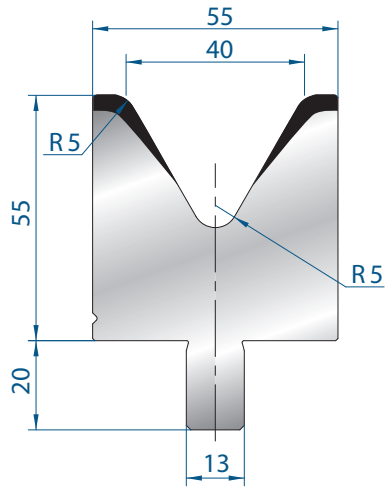


3112

Mat = C45
Max T/m = 100
 $\alpha = 85^\circ$

1000 mm	21,0 kg
500 mm	10,0 kg
1100 mm FRAZ. / SECT.	21,0 kg
100 mm	2,0 kg

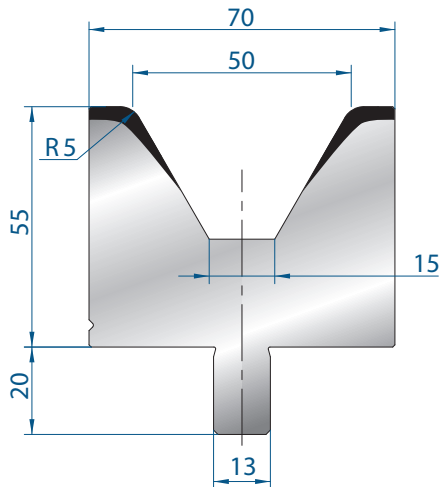




3113

Mat = C45
Max T/m = 100
 $\alpha = 60^\circ$

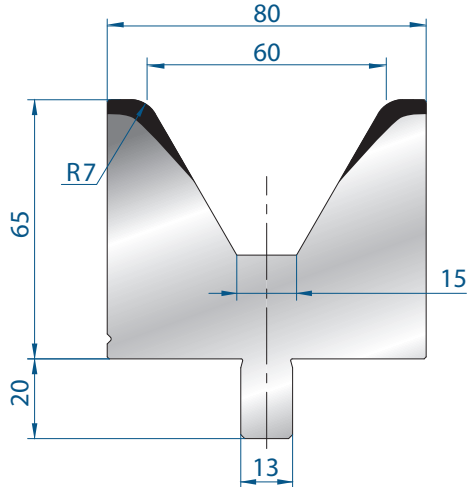
1000 mm	20,0 kg
500 mm	10,0 kg
1100 mm FRAZ. / SECT.	20,0 kg
100 mm	2,0 kg



3179

Mat = C45
Max T/m = 100
 $\alpha = 60^\circ$

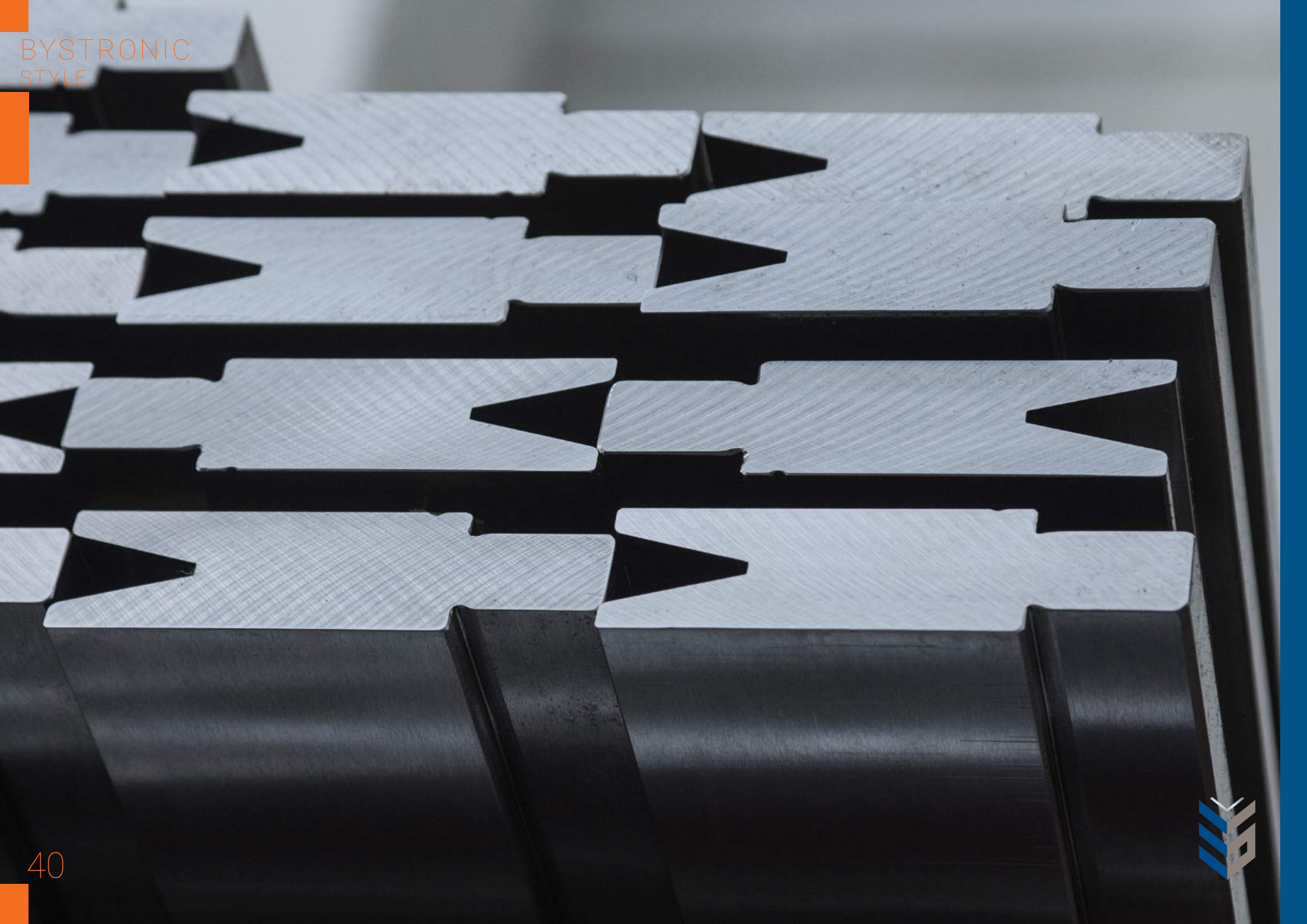
1000 mm	24,0 kg
500 mm	12,0 kg
1100 mm FRAZ. / SECT.	24,0 kg
100 mm	2,4 kg



3114

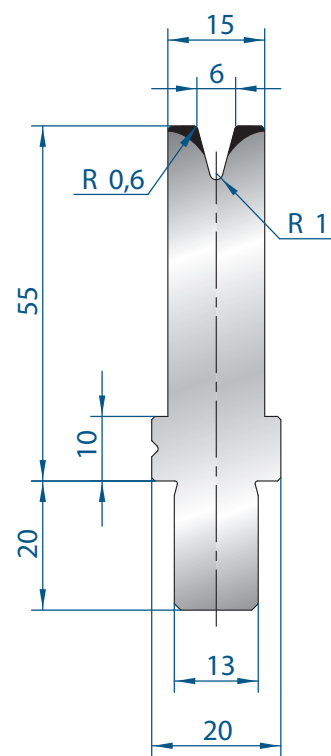
Mat = C45
Max T/m = 100
 $\alpha = 60^\circ$

1000 mm	31,0 kg
500 mm	15,0 kg
1100 mm FRAZ. / SECT.	31,0 kg
100 mm	3,0 kg



BYSTRONIC
STYLE

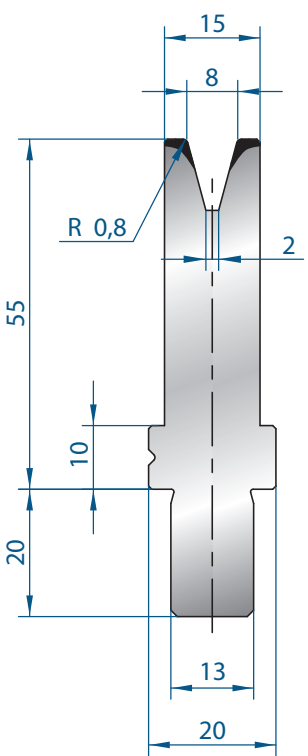




3115

Mat = C45
Max T/m = 35
 $\alpha = 30^\circ$

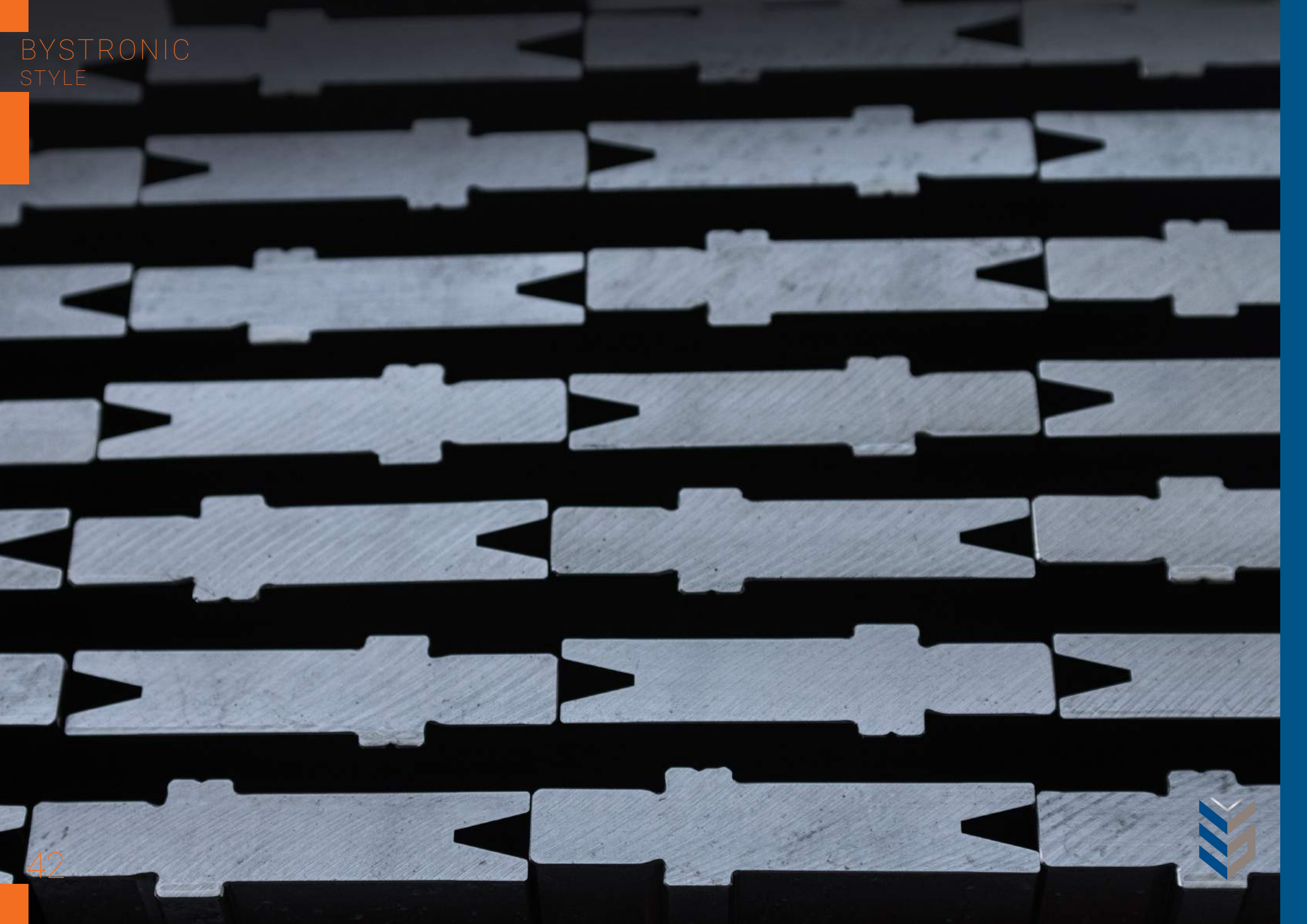
1000 mm	8,0 kg
500 mm	4,0 kg
1100 mm FRAZ. / SECT.	8,0 kg
100 mm	0,8 kg



3116

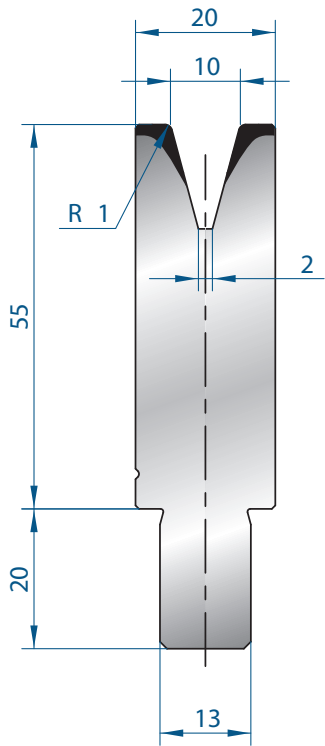
Mat = C45
Max T/m = 40
 $\alpha = 30^\circ$

1000 mm	8,0 kg
500 mm	4,0 kg
1100 mm FRAZ. / SECT.	8,0 kg
100 mm	0,8 kg



BYSTRONIC
STYLE

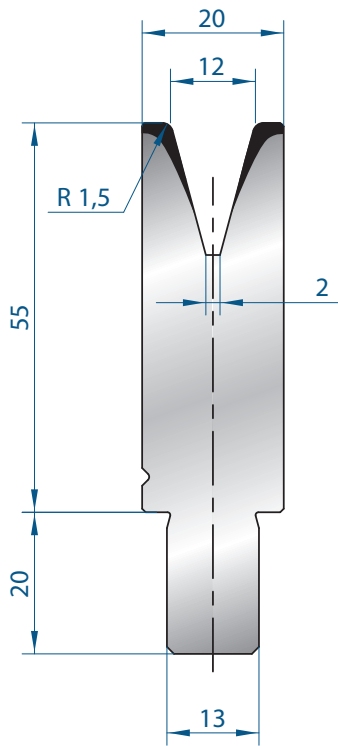




3117

Mat = C45
Max T/m = 50
 $\alpha = 30^\circ$

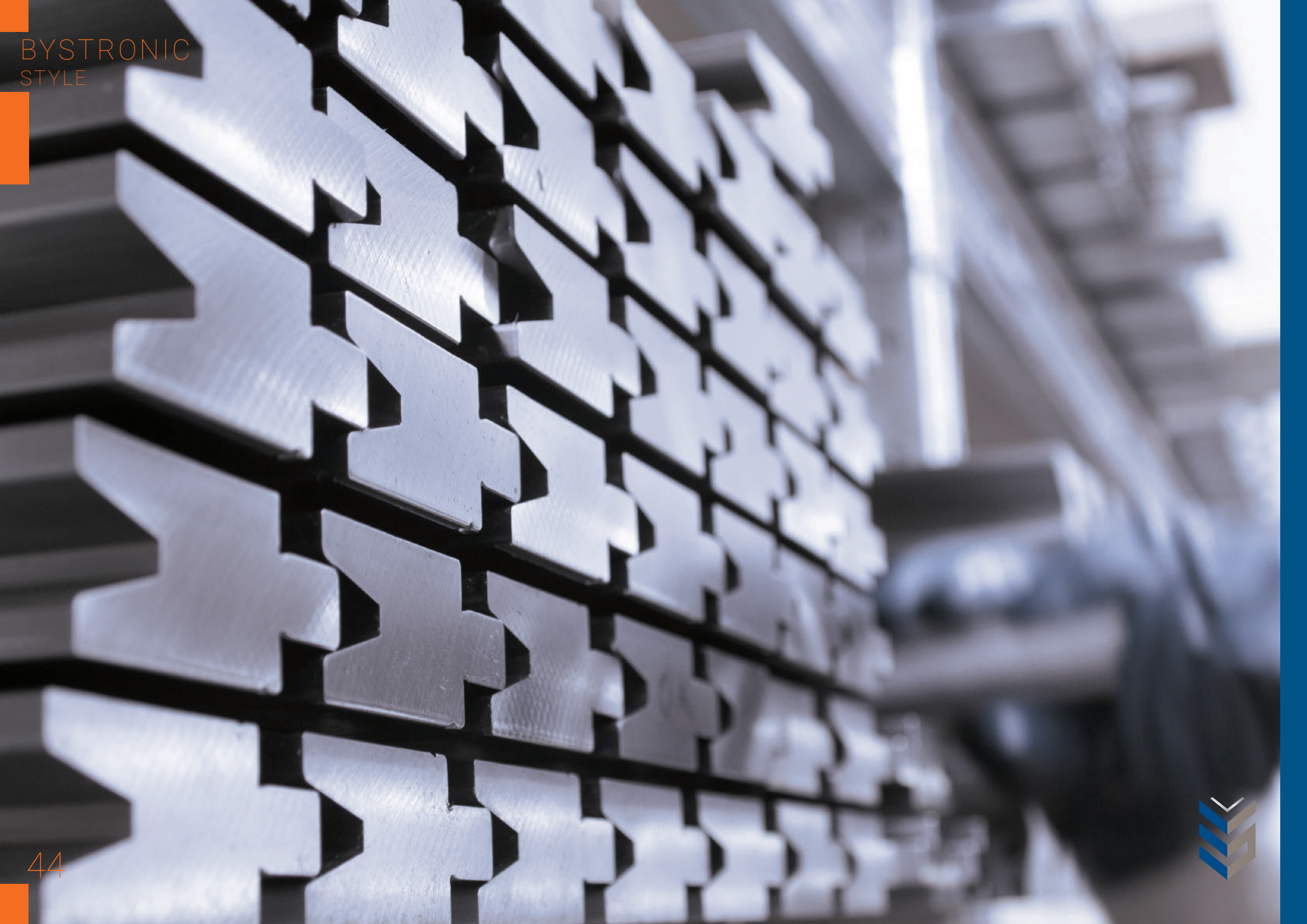
1000 mm	10,0 kg
500 mm	5,0 kg
1100 mm FRAZ. / SECT.	10,0 kg
100 mm	2,5 kg



3118

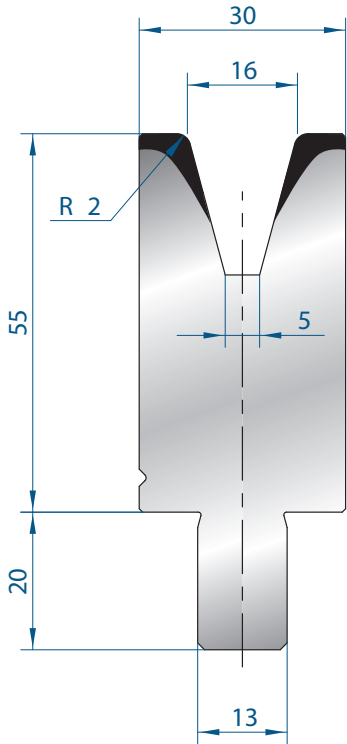
Mat = C45
Max T/m = 40
 $\alpha = 30^\circ$

1000 mm	10,0 kg
500 mm	5,0 kg
1100 mm FRAZ. / SECT.	10,0 kg
100 mm	2,5 kg



BYSTRONIC
STYLE

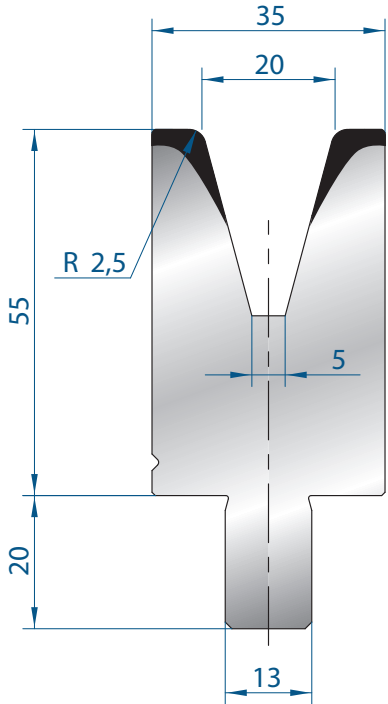




3119

Mat = C45
Max T/m = 50
 $\alpha = 30^\circ$

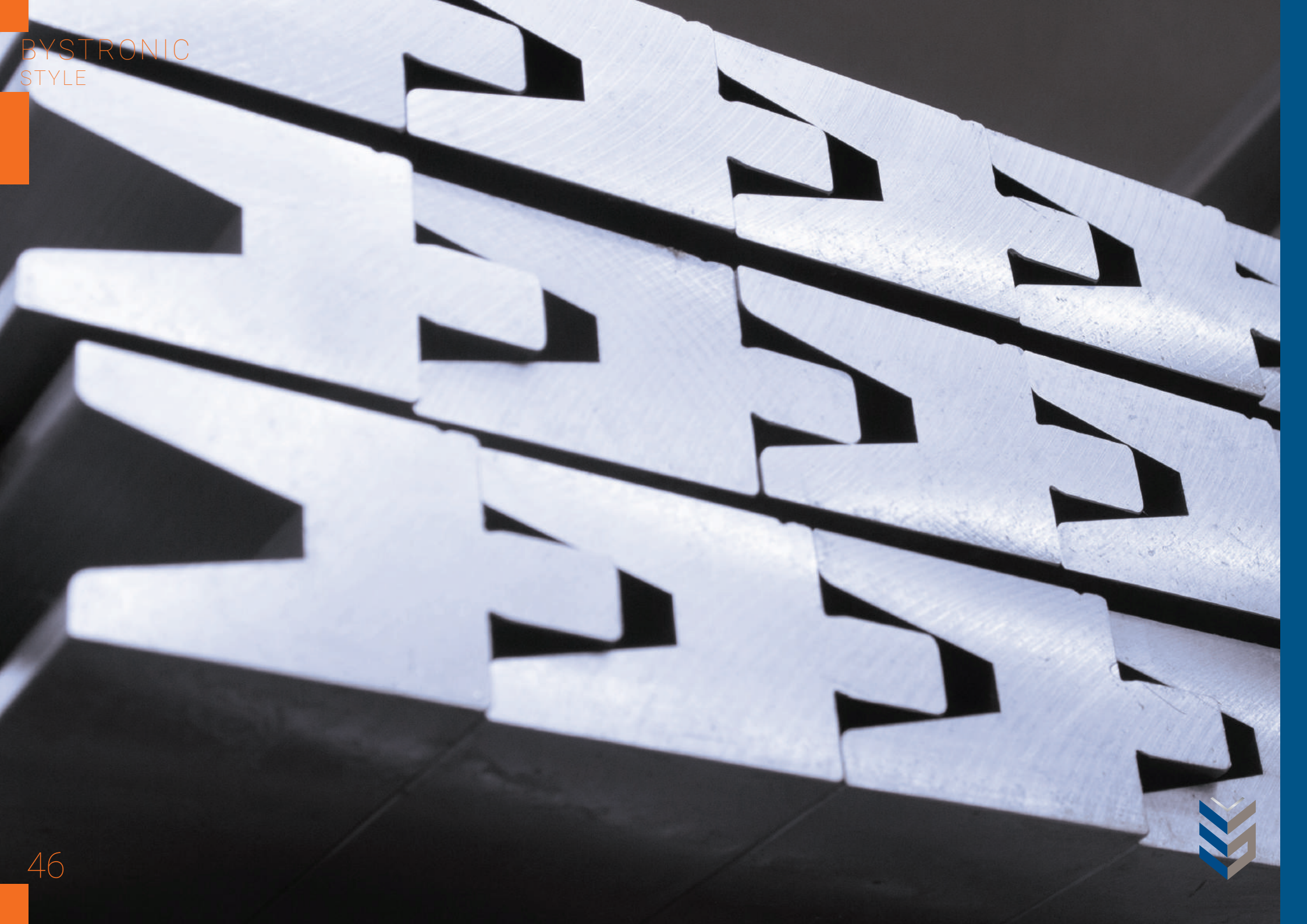
1000 mm	13,0 kg
500 mm	6,0 kg
1100 mm FRAZ. / SECT.	13,0 kg
100 mm	1,2 kg



3120

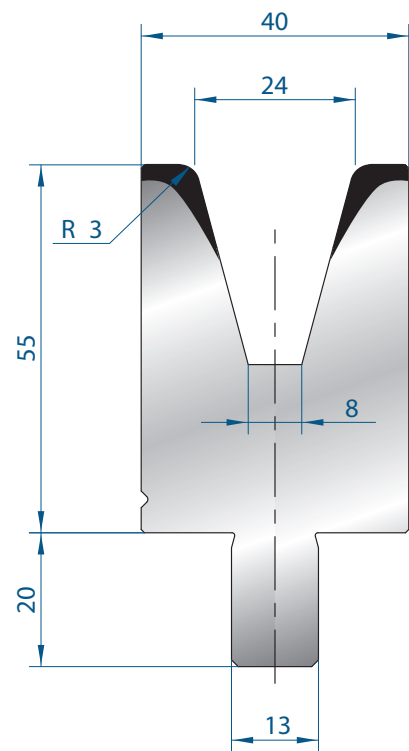
Mat = C45
Max T/m = 55
 $\alpha = 30^\circ$

1000 mm	14,0 kg
500 mm	7,0 kg
1100 mm FRAZ. / SECT.	14,0 kg
100 mm	1,4 kg



BYSTRONIC
STYLE

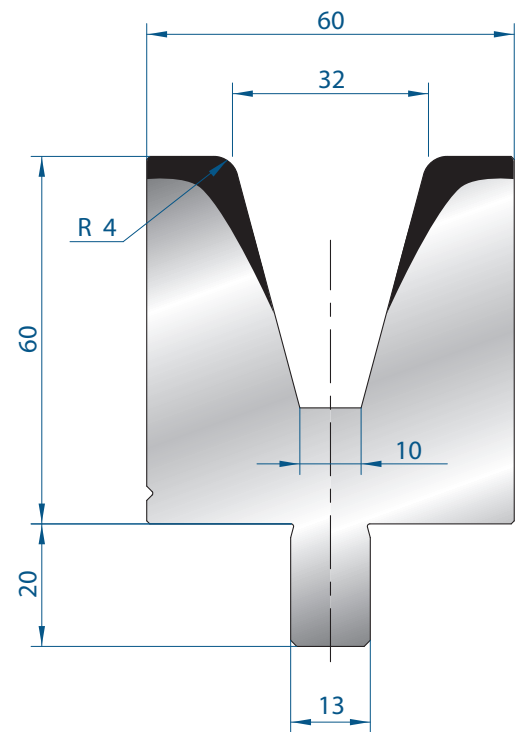




3121

Mat = C45
Max T/m = 65
 $\alpha = 30^\circ$

1000 mm	15,0 kg
500 mm	7,0 kg
1100 mm FRAZ. / SECT.	15,0 kg
100 mm	1,4 kg

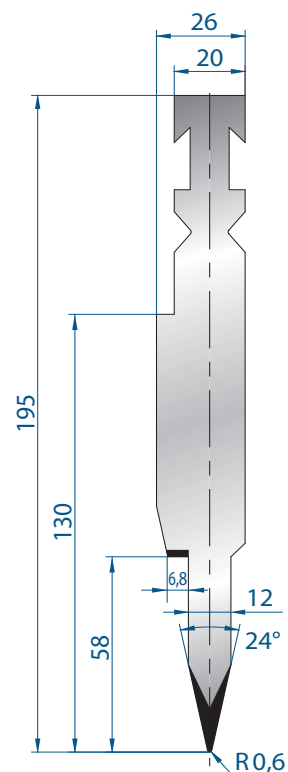


3122

Mat = C45
Max T/m = 65
 $\alpha = 30^\circ$

1000 mm	23,0 kg
500 mm	11,0 kg
1100 mm FRAZ. / SECT.	23,0 kg
100 mm	2,2 kg

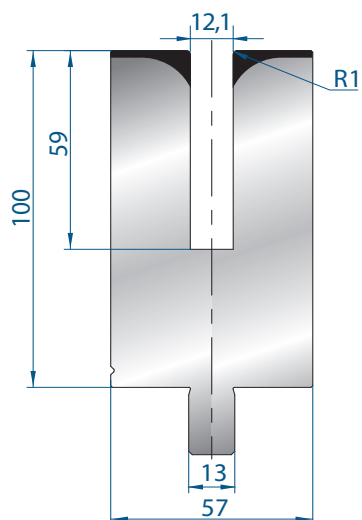


500-550 Frazionato (Bonificato) / Sectioned (Quenched)

1254

Mat = C45
bonificato / tempered
Max T/m = 80

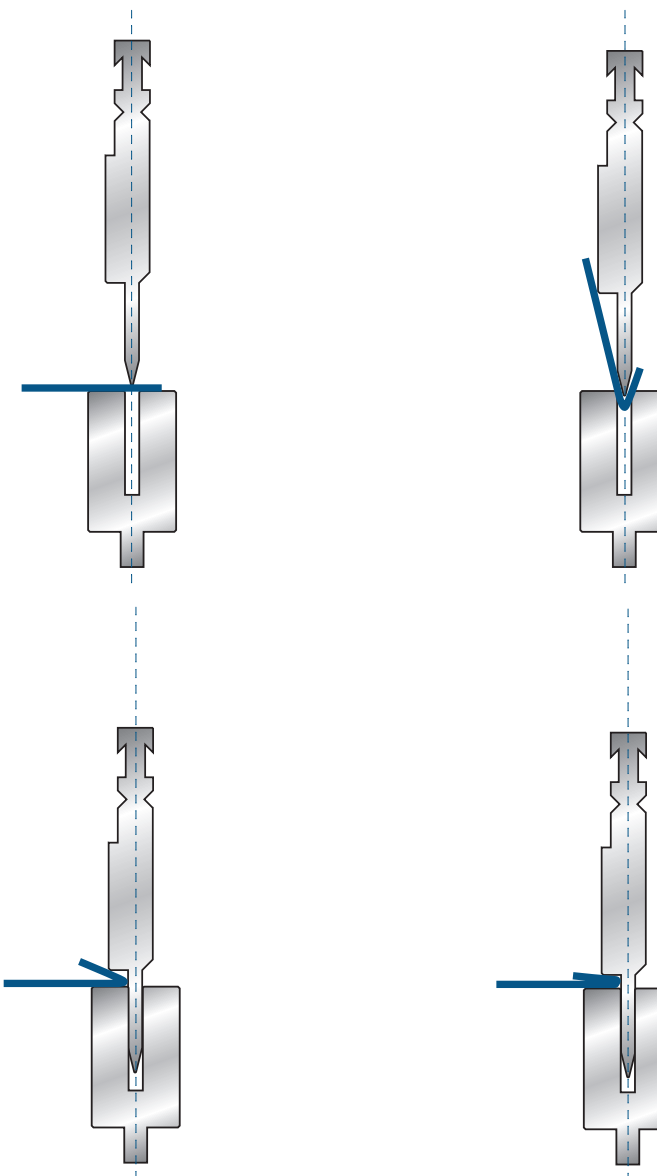
500 mm	14,0 kg
1100 mm FRAZ. / SECT.	14,0 kg
100 mm	2,8 kg

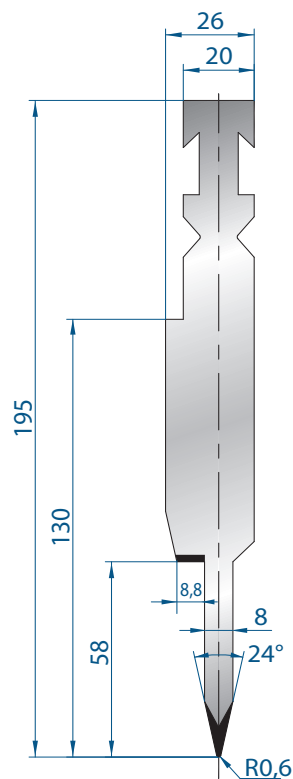
Spessore:
Max 1,5 mm Ferro
Thickness
Max 1,5 mm Mild steel


3175

Mat = C45
bonificato / tempered
Max T/m = 50

500 mm	20,0 kg
550 mm FRAZ. / SECT.	20,0 kg
100 mm	4,0 kg



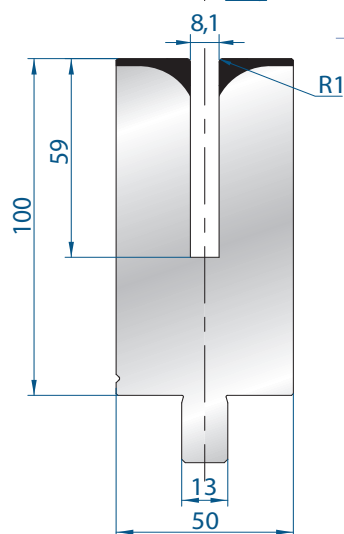


1252

Mat = C45
bonificato / tempered
Max T/m = 80

500 mm	13,0 kg
1100 mm FRAZ. / SECT.	13,0 kg
100 mm	2,6 kg

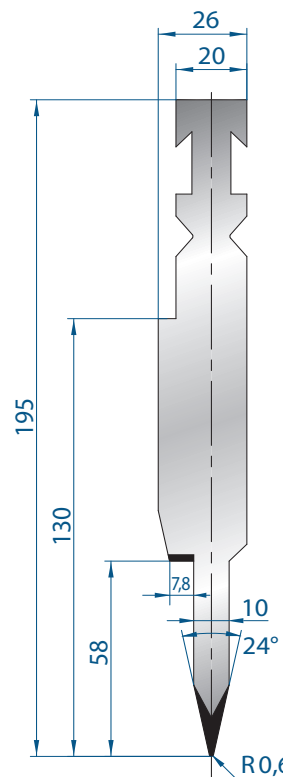
Spessore:
Max 1,2 mm Ferro
Thickness
Max 1,2 mm Mild steel



3157

Mat = C45
bonificato / tempered
Max T/m = 50

500 mm	21,0 kg
550 mm FRAZ. / SECT.	21,0 kg
100 mm	4,2 kg

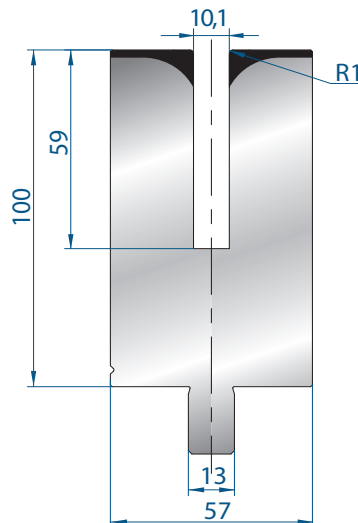


1253

Mat = C45
bonificato / tempered
Max T/m = 80

500 mm	13,0 kg
1100 mm FRAZ. / SECT.	13,0 kg
100 mm	2,6 kg

Spessore:
Max 1,5 mm Ferro
Thickness
Max 1,5 mm Mild steel



3174

Mat = C45
bonificato / tempered
Max T/m = 50

500 mm	20,0 kg
550 mm FRAZ. / SECT.	20,0 kg
100 mm	4,0 kg





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Eurostamp srl

sede di produzione / production site
uffici commerciali / sales office

Via A. Borotti 9/11
29121 Piacenza (Italy)
Tel. +39 0523 489 954
Tel. +39 0523 499 254
Fax +39 0523 400 490
info@eurostampsrl.it

www.eurostampsrl.it